

SPLIT

22791B

DART AEROSPACE LTD	Work Order:	22791B
Description: Doubler 04.11.25 48 Dwg: D3302 Rev. A BK 31 April 2001	Part Number:	D3302-1
04.11.25 48 Dwg: D3302 Rev. A BK 31 April 2001	Qty:	10 2x Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	PF	05.03.22	20
2	MV	Cut blank: 12.900" x 7.850" 13.150" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-1		SA	05.03.22 20
3	MV	Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-1	EP	05/03/23	20
4	QC2	Inspect parts as they come off the CNC machine	EP	05/03/23	20
5	QC8	Second check	ML	05/03/23	20
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	Z	05.03.24	10
7	GB	Form as per Dwg D3302	Z	05.03.24	10
8	QC5	Inspect work to Step 7	AD	05/03/28	10
9	FP	Chemical Conversion Coat as per QSI 005 4.1	JG	05/03/29	10
10	QC3	Inspect Chemical Conversion Coat	W	05.03.29	10
11	ST	Identify and Stock	KD	05/03/31	10
12	AC	Cost / part 46.36	SAC	05.04.01	10
13	DC	Close W/O 90,39 Inspect Level 21	KJ	05.04.05	10

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	JLM

RELEASED
R. J. L. 07/07/07

DART AEROSPACE LTD	Work Order:	22791
Description: Doubler	Part Number:	D3302-1
Inspection Dwg: D3302	Rev: B ¹	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <i>EP</i>	Audited by: <i>BL</i>	Prototype Approval: N/A
Date: 05/03/23	Date: 05/03/23	Date: N/A

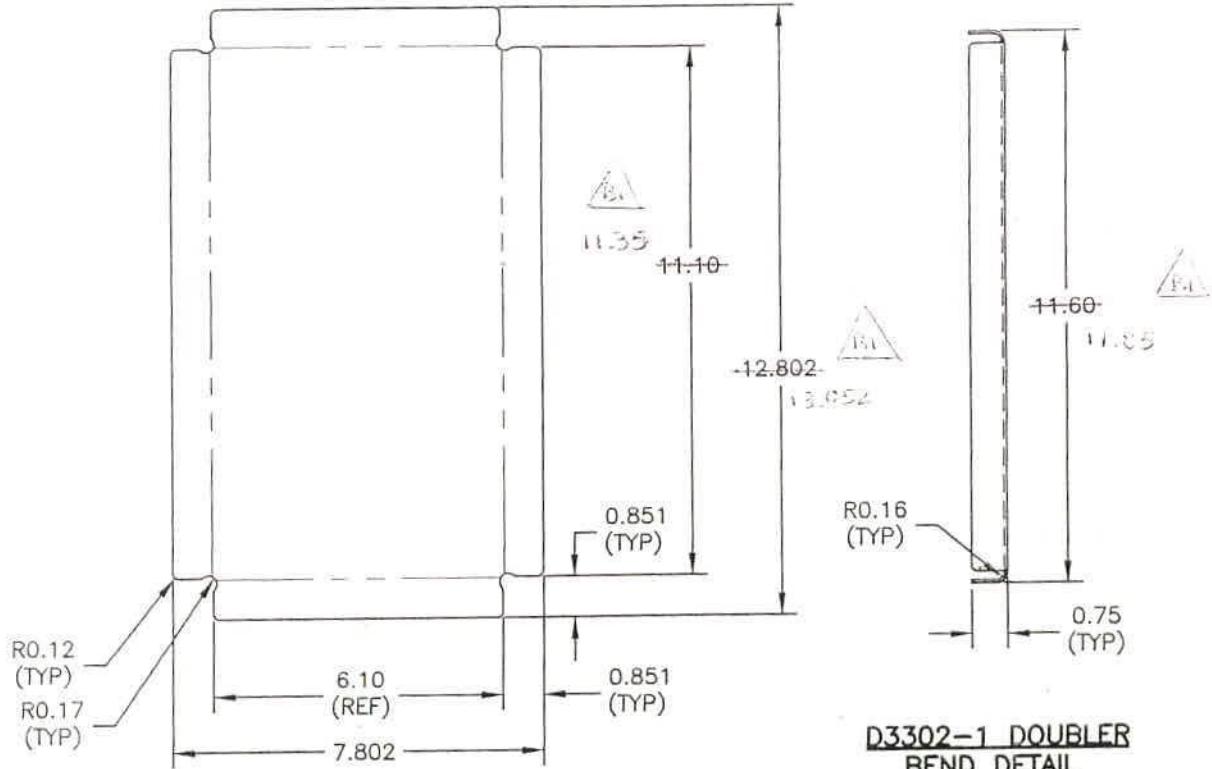
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	<i>[Signature]</i>
B	05.03.04	Revised dimensions per Dwg revision	KJ/JLM	<i>[Signature]</i>

RE-
RELEASED
10/05/08

DART

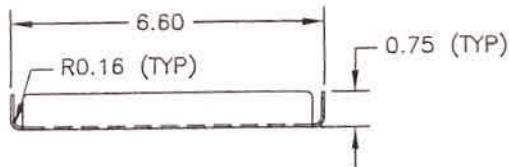
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3302	SHEET 1 OF 4
DATE		TITLE	SCALE
04.11.18		DOUBLER	1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	RF 04.12.15	ADDED 0.15" TO THIS dimension FOR -1/-3	
B2	RF 05.05.21	7.30 was 7.34; 8.997 was 9.042; 7.75 was 7.84; FOR D3302-3	

RELEASED
04.11.23



D3302-1 FLAT PATTERN

PRELIMINARY ISSUE



D3302-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

STOCK COPY
NOT TO
BE USED
UNIT 11
S2011
W000000000
NO. 22791

Job Costing Report

Dart Aerospace Ltd.
HawkesburyMar 21, 2005
10:23 am

Work Order No : 0022791
 Project Name : D3302-1
 Project For : WK513
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3302-1
 Description : Doubler
 Manufactured : Yes
 Amount Req'd : 20
 Amount Done : 0
 Start Date : 03-21-05
 Est Finish Date : 03-30-05
 Act Finish Date :
 Drawings Rqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Total Cost :	0.00	0.00	0.00	0.00	0.00
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			
	Estimated	Actual			
Labour Hrs/Amount Done :	0.00	0.00			
Profits/ (Loss) :	0.00	0.00			